

Work Order ID 66440

Monday, February 14, 2011 2:55:01 PM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Item Name: Automatic Door Opener, LH/RH

Stop



Start Date: 2/15/2011 Start Qty: 6.00

Cust Item ID:

Ship Wedn.

Required Date: 2/16/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: mmk Date: 11-02-14

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100 0.00

DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy bluefile & type labels per PPP D412-698-023

CHG002

8/16/16

110 0.00

Pick Kit

Packaging Memo 0.00

Packaging

11/2/15

@sf

120 0.00

QC4- 100% Inspect kits for completeness

QC Memo 0.00

Quality Control

8/16/16

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10B</u>								
	PPP Rev: <u>B</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/2/16 SP 62

11/02/16

mf
11-02-16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 66440

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L Washer	NAS1149D0516J	Purchased	No			120	Each	51.0000	2	12 11/2/15			sf
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Location	Loc Qty	Loc Code
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ST347	51	
112466	51	

D3552-11 Door Prop		Manufactured	No			120	Each	16.0000	1	6 11/2/15			sf
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Location	Loc Qty	Loc Code
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ST272	16	
65130	4	
65391	12	

D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	12.0000	1	6 11/2/15			sf
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Location	Loc Qty	Loc Code
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ST234B	12	
65160	12	

D3594-044 Floor Doubler Assembly, RH		Manufactured	No			120	Each	15.0000	1	6 11/2/15			sf
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Location	Loc Qty	Loc Code
----------	---------	----------

ST234B	15	
65161	15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 66440

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

S₇₆ D3594-5
Door Doubler

Manufactured No

120

Each

12.0000



6
11/2/15 SP

Location

Loc Qty

Loc Code

ST234A

12

64086

12

6
12

S₇₆ D3622-1
Ball Stud

Manufactured No

120

Each

0.0000



2
12
B66187 11/2/15 SP

S₇₆ MS20426AD4-4
Rivet

Purchased No

120

Each

3,070.000



2
12
11/2/15 SP

Location

Loc Qty

Loc Code

ST316

47

15541

47

12

ST317

3023

116188

3023

S₇₆ MS21073L5
nut plate

Purchased No

120

Each

77.0000



1
6
11/2/15 SP (6)

Location

Loc Qty

Loc Code

ST303

77

113660

57

116583

20

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW